



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5101-047
Job Sheet 181661



Part No: D5101-047

Job Qty: 10 ea

Part Name: Crossbolt Spacer Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/3/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 5,6 IPP Rev.A New issue JFS 15/09/29 Verified by: DD IPP REV:B 15.12.10 AS PER
DWG REVB DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	8/17/18	8/17/18	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	10 pcs	8/17/18	8/17/18	0.00	8.00	HAAS 5 Axis		
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-3		
130	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-3		
140	Small Fab	10 pcs	8/17/18	8/17/18	0.00	1.00	Small Fab-8		
170	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC5		
180	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		
190	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 100 - Cut blank 2.200" long

Descriptions: 110 - 1- Mill as per Folio FB426 DWG Rev: _____ FOLIO REV: _____ 2-Deburr per dwg

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB1.000X4.000	Delrin Bar	1.8400 ft (.184 ea)	90-Start up Operation	S029737-S103113
MS21209F7-10	Heli-Coil, Locking	40 Ea (4 ea)	140-Small Fab	2097455

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINB1.000X4.000	2	14	0
140-Small Fab	MS21209F7-10	40	224	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Re: _____		Water Jet ☐ Engineering ☐	
NCR No. _____		Use _____		I. Eng. Coord. ☐ Quality ☐	
		Suspected Unappr		e/Packaging ☐ Other ☐	
Date: _____		Step #: _____		MRB (QSI042) Approval	
Description Work Order Deviation				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	Date: 08/15/18 Container No: S103114 Part: D5101-047 Job No: 181661 Serial No/Batch: S103114 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STCs DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Drill Holes		
Design ☐	☐ Operator	☐ Bending			
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric			
Equip/Tooling ☐	☐ Supplier	☐ Cracks			
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/			
Material ☐	☐ Use for Testing	☐ Cuffs			
Internal Transport ☐	☐ Poor Information	☐ Crushing			
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat			
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tub			
Substation ☐	☐ Process Improvement	☐ Marks/Chatter			
Past Expiry Date ☐	☐ Manufacturing Process				
Misidentified ☐	☐ Past Due	OTHER: _____			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					